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D5377-1

Job Sheet 191667



Part No: D5377-1

Job Qty: 6 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	6 pcs	4/2/19	4/2/19	0.00	3.49	Waterjet - Flow		OK 19/03/15
130	HAAS 4 Axis - B4B	6 pcs	4/2/19	4/2/19	0.62	15.38	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	6 pcs	4/2/19	4/2/19	0.00	0.00	QC 2 - 1		OK - 19/03/20
							QC 2 - 12		OK 19/03/20
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		

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150 QC 8	6 pcs	4/2/19	0.00	0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
151 Packaging 3-1 - Stock - B4B	6 pcs	4/2/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	

DAS
52
9-89

12/03/21

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	4/2/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - Cut Blank as per D5377-1_blank File

Descriptions: 130 - (HAAS CNC Vertical Machine), 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

140 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (QC8- Inspect parts - second check)

151 - (Identify as per dwg & Stock Location:_____)

190 - (QC21- Final Inspection - Work Order Release)

DAG
21
9-00

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	33.8400 sf (5.64 ea)	120-Waterjet - Flow - 1	S143330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	34	846	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches ± 0.030	0.410 0.350	0.380	
2	Bearpaw	5.000Inches ± 0.030	5.030 4.970	5.000	
3	Bearpaw	3.930Inches ± 0.030	3.960 3.900	3.930	
4	Bearpaw	1.380Inches ± 0.030	1.410 1.350	1.380	
5	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.500	
6	Bearpaw	1.720Inches ± 0.030	1.750 1.690	1.720	
7	Bearpaw	2.0Degrees ± 0.0	2.0 2.0	2.0	
8	Bearpaw	15.440Inches ± 0.030	15.470 15.410	15.44	
9	Bearpaw	4.688Inches ± 0.010	4.698 4.678	4.688	
10	Bearpaw	0.756Inches ± 0.010	0.766 0.746	0.756	
11	Bearpaw	0.700Inches ± 0.010	0.710 0.690	0.700	
12	Bearpaw	24.000Inches ± 0.030	24.030 23.970	24.00	
13	Bearpaw	21.340Inches ± 0.030	21.370 21.310	21.340	
14	Bearpaw	6.400Inches ± 0.030	6.430 6.370	6.400	
15	Bearpaw	3.520Inches ± 0.030	3.550 3.490	3.520	
16	Bearpaw	0.240Inches ± 0.030	0.270 0.210	0.250	
17	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250	Radius
18	Bearpaw	0.300Inches ± 0.030	0.330 0.270	0.300	
19	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	45.0	
20	Bearpaw	0.500Inches ± 0.030	0.530 0.470	0.500	
21	Bearpaw	0.740Inches ± 0.030	0.770 0.710	0.740	
22	Bearpaw	0.950Inches ± 0.030	0.980 0.920	0.960	
23	Bearpaw	0.261Inches + 0.006 - 0.001	0.267 0.260	0.261	
24	Bearpaw	0.500Inches ± 0.010	0.510 0.490	0.500	
25	Bearpaw	0.060Inches ± 0.030	0.090 0.030	0.060	
26	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	45.00	
27	Bearpaw	0.460Inches ± 0.010	0.470 0.450	0.460	
28	Bearpaw	0.650Inches ± 0.010	0.660 0.640	0.650	
29	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.375	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S163156



Part: D5377-1

Job No: 191667

Serial No/Batch: S163156

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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